

Date: Tuesday, 7/10/2007 1:05:44 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 33450		
Estimate Number	: 10178	Part Number	: D25941
P.O. Number	: <i>N/A</i>	Drawing Number	: D2594 REV C
This Issue	: 7/10/2007 S.O. No. : <i>N/A</i>	Project Number	: <i>N/A</i>
Prsht Rev.	: <i>NC</i>	Drawing Revision	: <i>C</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Material	: <i>N/A</i>
Previous Run	: 32651	Due Date	: 7/23/2007
Written By	: <i>[Signature]</i>	Qty:	500 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)  
Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
1100-0 (QQ-A-225/1) Ø0.625" Rod  
(M5052H32R0.625) or (M6061T6R0.625) Batch *M10603*

*28.5'**RP 07/11/08**DIP 07/11/07*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
1-Make as per Dwg D2594-1 and Folio FA262.  
2-Break all sharp edges 0.010 max.

*DIP 07/11/07**RP 07/11/08*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*RP 07/11/08**(SIC)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*RP 07/11/08**(SIC)*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Acid etch and alodine as per QSI 005 4.1

*RP 07-11-09**(SIC)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:44 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 33450

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



*M-105914*



*(516)*

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

*FL 07/11/14*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(516X)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-1 07/11/14*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



*(516X)*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP 8*

*M-1 07/11/14*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*(516)*

Comment: FINAL INSPECTION/W/O RELEASE

*LD 07/11/15*

Job Completion



*W 07-11-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	33450
Description: Plug		Part Number:	D2594-1
Inspection Dwg: D2594 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	0.060	✓			
0.500	+/-0.010	0.500	✓			
0.625	+/-0.010	0.622	✓			
0.430	+0.000/-0.002	0.430	✓			
0.090	+0.000/-0.002	0.088	✓			
0.045	+0.000/-0.002	0.045	✓			
0.060	± 0.005	0.059	✓			

Measured by: DIP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/11/07	Date: 07/11/07	Date:	

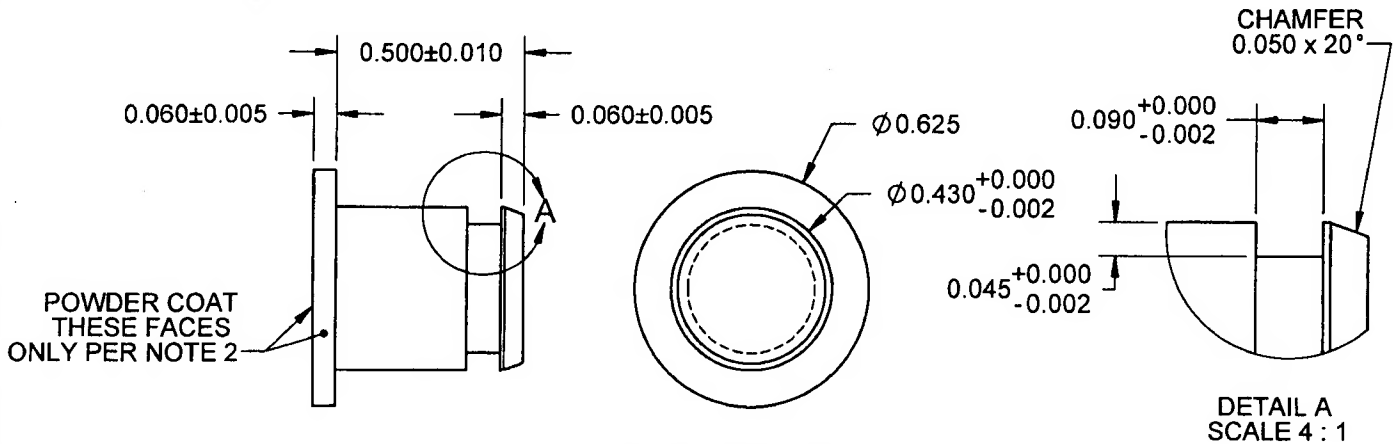
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM [Signature]	[Signature]

**DART**

DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

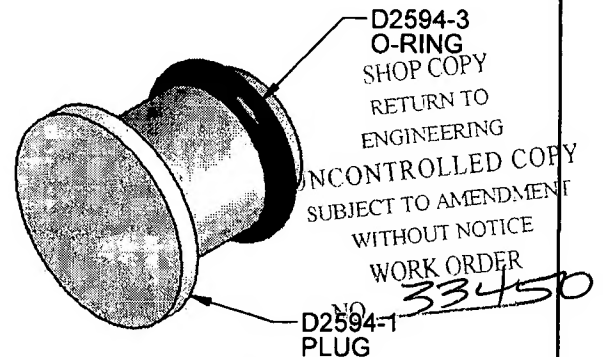
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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